

Work Order ID 74709

Wednesday, October 05, 2011 12:55:43 PM

Page 1



Item ID: D4275-1

Accept



Setup Start



Revision ID:

Item Name: Fwd Beam

Stop



Start Date: 10/5/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 11/10/05

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4275	A								

100

0.00



BAND SAW

Bandsaw

Jeaspa Bandsaw

Memo

Cut Blank to 39.750"

Batch: M120243

M119346

0.00

OK 12/02/28

4

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

HAAS CNC vertical machine #1

Memo

1-Machine per folio FB006

DWG REV: A

FOLIO REV: AA

0.00

SL 12-03-03

#10

2- deburr rough edges

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74709

Wednesday, October 05, 2011 12:55:43 PM

Page 2

Item ID: D4275-1

Accept

Revision ID:

Item Name: Fwd Beam

Start Date: 10/5/2011 Start Qty: 4.00

Required Date: 10/14/2011 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74709

Wednesday, October 05, 2011 12:55:43 PM



Page 3

Item ID: D4275-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Beam

Start Date: 10/5/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

145

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

3h30

0.00

MASK AS PER DWG

4h00

Powder Coating

M120222

320°F

24 Q

2011 12/03/05

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4X M-12/03/06

180

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

4X 12-03-6 Sp

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74709

Wednesday, October 05, 2011 12:55:43 PM

Page 4

Item ID: D4275-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Fwd Beam

Start Date: 10/5/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

12/3/7

1203-4
4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, October 05, 2011 12:55:49 PM

Page 1

Work Order ID: 74709



Parent Item: D4275-1



Parent Item Name: Fwd Beam

Start Date: 10/5/2011

Required Date: 10/14/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-11-17 JLM VERIFIED BY:DD IPP rev:B
10.12.02 AS PER DWG REV.A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00 0		Purchased	No			100	f	25.7870	3.3125	13.94737			



6061-T6 Bar 1.00 x 4.00



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT004	25.787	
114352	1	
116808	0.787	
118400	24	

M120243 X 10.43'

M119346 X 3.52

on 12/02/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	34709
Description: Fwd Beam		Part Number:	D4275-1
Inspection Dwg: D4275 Rev: A		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	.750	/		vern	JL-3
26.700	+/-0.010	26.70	/		m-tape	
Ø0.381	+0.000/-0.001	.381	/		pins	
8.280	+/-0.010	8.280	/		H-G	
1.44	+/-0.030	1.44	/		-	
0.95	+/-0.030	.949	/		-	
3.50	+/-0.030	3.500	/		vern	JL-3
13.28	+/-0.030	13.28	/		m-tape	
13.50	+/-0.030	13.50	/		-	
9.25	+/-0.030	9.25	/		-	
5.00	+/-0.030	5.00	/		vern	JL-3
0.75	+/-0.030	.750	/		-	
2.75	+/-0.030	2.75	/		-	
3.00	+/-0.030	3.00	/		-	
1.250	+/-0.010	1.250	/		H-G	
4.50	+/-0.030	4.50	/		vern	JL-3
0.734	+/-0.010	.735	/		-	
0.108	+/-0.010	.107	/		H-G	
39.48	+/-0.030	39.48	/		m-tape	
0.95	+/-0.030	.949	/		vern	JL-3
0.60	+/-0.030	.598	/		-	
1.750	+/-0.010	1.750	/		-	
2.700	+/-0.010	2.699	/		-	
1.10	+/-0.030	1.100	/		-	
1.25	+/-0.030	1.248	/		-	
0.900	+/-0.010	.899	/		H-G	
0.75	+/-0.030	.749	/		-	
0.250	+/-0.010	.250	/		-	
3.000	+/-0.010	3.000	/		vern	JL-3
1.500	+/-0.010	1.500	/		-	
Ø0.191	+0.005/-0.001	.193	/		-	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

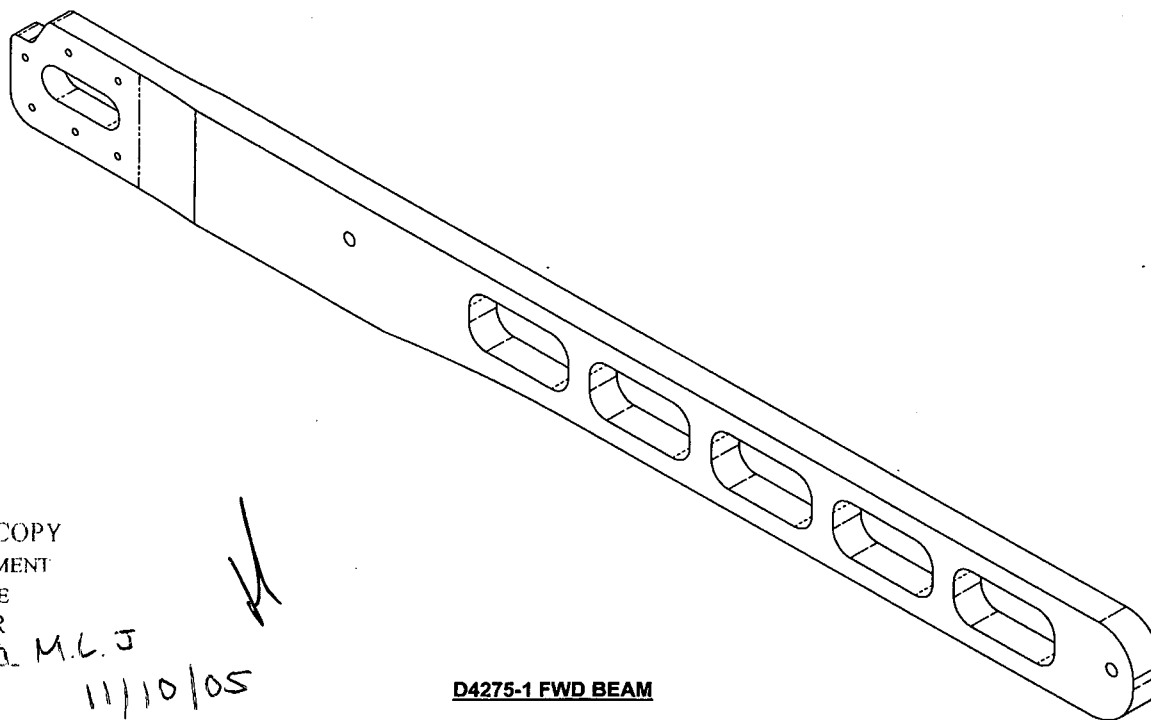
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 74709 M.L.J
11/10/05



D4275-1 FWD BEAM

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
 PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
 OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
 OR ASTM B211 OR ASTM B221
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 8.29 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT.

RELEASED
 2010-11-30

A		NEW ISSUE		SC	10.11.25
REV.	DESCRIPTION			BY	DATE
DESIGN	SC	DART AEROSPACE LTD			
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO.	REV. A		
MFG. APPR.		D4275	SHEET 1 OF 2		
APPROVED		TITLE	SCALE		
DE APPR.		FWD BEAM	UNITS		
DATE	10.11.25				
<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSONS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

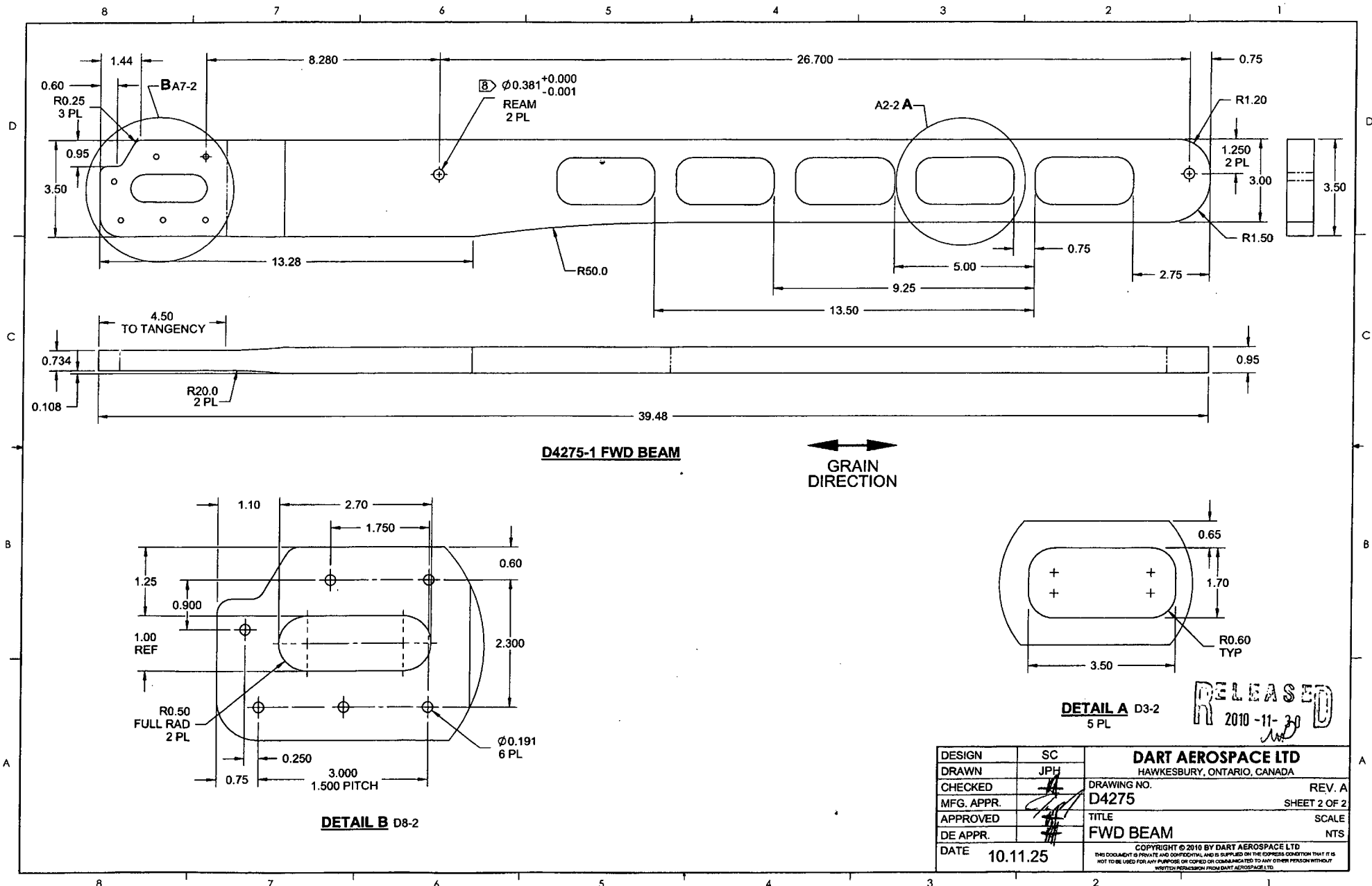
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74709



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries